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RBE117-15004W6
Job Sheet 191217



Part No: RBE117-15004W6

Job Qty: 1 pcs

Part Name: Push Out / Press In Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 4/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 13707*

Note: DWG RBE117-15004W6 Rev.1 IPP Rev. A 18.12.20 New issue DP Verify DD

Ship Via:

Bill of Materials



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Container No: S178740



Part: RBE117-15004W6

Job No: 191217

Serial No/Batch: S178740

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 05/07/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/22/19		0.00	1.00	Small Fab - 1		DAS 71 9-89 19-5-6
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	4/22/19		0.00	0.00	QC 5 - 10		68-6 30 DAS MAY 07 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Packaging 3-1 - Stock - B4B	1 pcs	4/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 46 9-89 MAY 07 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	1 pcs	4/22/19		0.00	0.00	QC 21 - FG - 21		DAS 21 9-89 MAY 07 2019
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - 1-Glue placard RBE117-15004W6-23 to RBE117-15004W6-21 foam as per DWG. 2-Glue foam to case and pack
Descriptions: case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1400-E	Case	1 Ea (1 ea)	100-Small Fab - 1	X S163781
RBE117-15004W6-1	Drift	1 pcs (1 ea)	100-Small Fab - 1	X S171895
RBE117-15004W6-15	Spacer Ring	1 pcs (1 ea)	100-Small Fab - 1	X S172239
RBE117-15004W6-17	Ring	1 pcs (1 ea)	100-Small Fab - 1	X S172174
RBE117-15004W6-19	Foam, Bottom	1 (1 ea)	100-Small Fab - 1	X S163778
RBE117-15004W6-21	Foam, Top	1 (1 ea)	100-Small Fab - 1	X S163780
RBE117-15004W6-23	Placard	1 pcs (1 ea)	100-Small Fab - 1	X S159427
RBE117-15004W6-3	Thrust Piece	1 pcs (1 ea)	100-Small Fab - 1	X S170954
RBE117-15004W6-5	Tube 1	1 pcs (1 ea)	100-Small Fab - 1	X S171099
RBE117-15004W6-7	Tube 2	1 pcs (1 ea)	100-Small Fab - 1	CS S173642
RBE117-15004W6-9	Thrust Assembly	1 pcs (1 ea)	100-Small Fab - 1	S178420

FG Dock

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1400-E	1	8	0
	RBE117-15004W6-1	1	0	0
	RBE117-15004W6-15	1	0	0
	RBE117-15004W6-17	1	0	0
	RBE117-15004W6-19	1	0	0
	RBE117-15004W6-21	1	0	0
	RBE117-15004W6-23	1	0	0
	RBE117-15004W6-3	1	0	0
	RBE117-15004W6-5	1	0	0
	RBE117-15004W6-7	1	0	0
	RBE117-15004W6-9	1	0	0

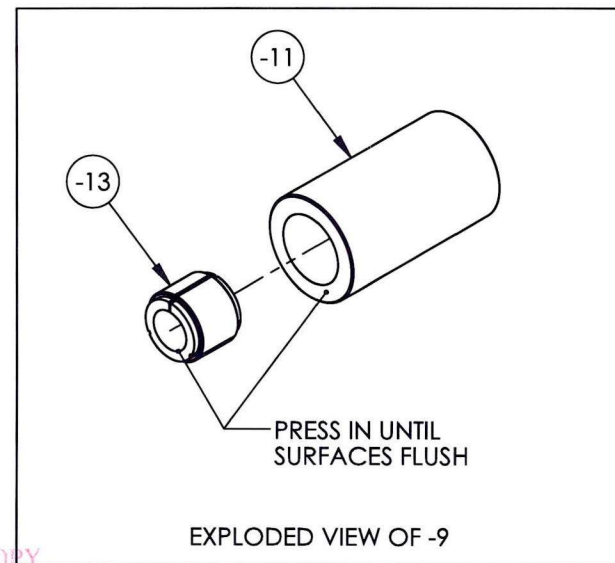
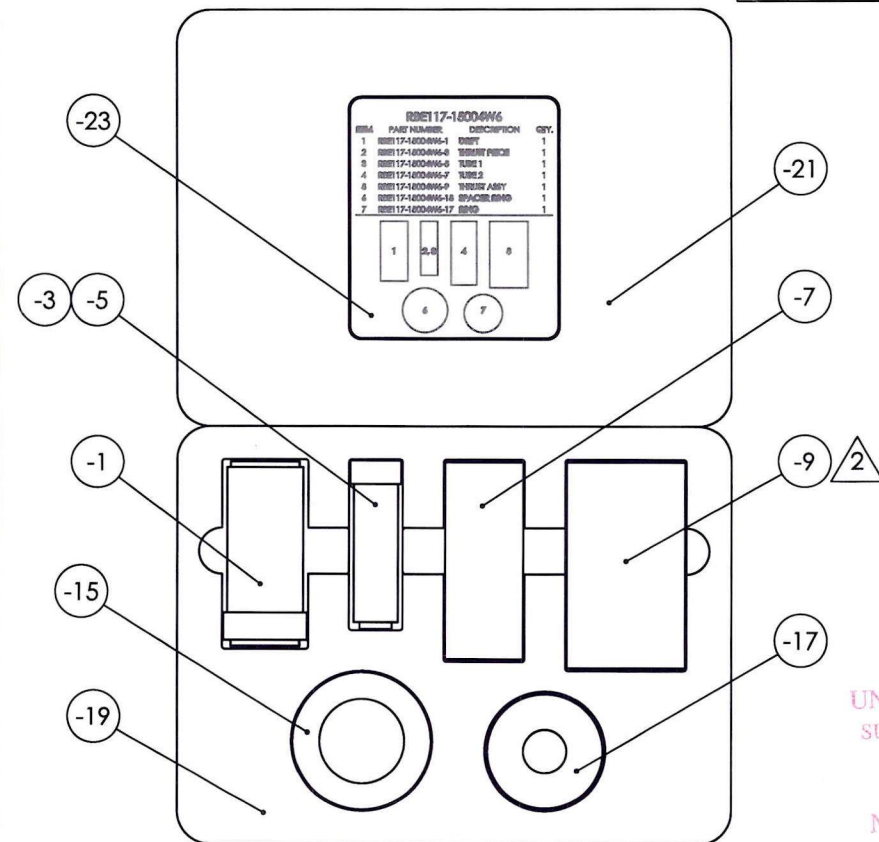
Part Specifications

Specifications could not be found.

Plex 2/25/19 9:28 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	11/9/2016	SM	JAG



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WORK ORDER
NO. 191217 M15
19-02-25

- NOTE:
1. REF. AIRBUS T/N 117-15004W6.
2. SEE EXPLODED VIEW OF -9.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	DRIFT	01		2
			-3	1	THRUST PIECE	4140/4142		3
			-5	1	TUBE 1	01		4
			-7	1	TUBE 2	01		5
	X		-9	1	THRUST ASSY			1
	1		-11	1	TUBE 4	01		6
	1		-13	1	THRUST PIECE	WHITE DELRIN/ACETAL		7
			-15	1	SPACER RING	01		8
			-17	1	RING	01		9
		B/O	-19	1	FOAM, BOTTOM	ETHAFOAM 220, BLACK	3.95 X 9.08 X 11.98 (CASE SOLUTIONS)	10
		B/O	-21	1	FOAM, TOP	ETHAFOAM 220, BLACK	1.20 X 9.08 X 11.98 (CASE SOLUTIONS)	11
			-23	1	PLACARD	PLASTIC		12
		B/O	-25	1	CASE	PLASTIC	PELICAN #APP-1400-E	N/S
	ASSY -9							

DART AEROSPACE	
TITLE PUSH OUT/PRESS IN TOOL	
DWG NO. RBE117-15004W6	REV 1
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 125° X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK	USED ON MODEL H145
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 8/17/2016
SHEET 1 OF 12	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					